

Work Order ID 50344

July 14, 2009 2:52:04 PM



Page 1

Item ID: D3120-2

Accept

Revision ID: B

Item Name: Cover

Setup Start

Stop

Start Date: 7/15/09 Start Qty: 2.00

Required Date: 7/15/09 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: C209107114

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3120

Rev B

110

0.00



HAAS CNC VERTICAL MACHINING #1

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3120

Prog rev: B

Dwg rev: B

Deburr as required

B 9-8-12

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 9-8-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50344

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Page 2

Item ID: D3120-2

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Setup Start



Revision ID: B

Stop



Item Name: Cover

Start Date: 7/15/09

Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Handwritten: 138 Bend as per dwg

Handwritten: 509/08/13

Handwritten: (46)

Handwritten: (4)

Handwritten: (4)

Handwritten: (40)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

Handwritten: 6/09-08-27

Handwritten: (5)

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

Handwritten: 1118260

Handwritten: 5/09/08/26

Handwritten: (5)

Handwritten: (5)

START TIME: 10:00AM OVEN TEMPERATURE:

10:30AM FINISH TIME: 3209~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3120-2 PAR #: N/A Fault Category: Prod- Small Fabs NCR: Yes No DQA: [Signature] Date: 05-08-01
Scrap / Scrap. QA: N/C Closed: [Signature] Date: 05-09-01

NCR: 50344		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/07	130	1 piece has a notch on it. Blow cut from water Jet. P.C. Machine Malfunction / process.	<u>[Signature]</u> 05/04/07	Scrap - destroy No replace	<u>SB</u> 09/03/07	<u>[Signature]</u> 09/06/07	<u>[Signature]</u> 05/04/07	<u>[Signature]</u> 05/06/07

NOTE: Date & initial all entries

Work Order ID 50344

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Page 3

Item ID: D3120-2

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cover

Start Date: 7/15/09

Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/09

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

BP 09-08-28

(5)



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location 237

0.00



Packaging

Memo

0.00

Packaging

9/8/28 (SV) SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/31 HJ

BP 09-8-28 (6)

Picklist Print

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Page 1

Work Order ID: 50344

Parent Item: D3120-2RevB

Parent Item Name: Cover

Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	111.0100	0.4587	6		



2024-T3 .032 sheet

B 9-8-12

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	111.01	
102942	1.5	
105555	5	
106272	8.47	
108595	3	
109240	7.02	
110778	34.02	
111699	49	
18147	3	

110778

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	50344
Description: COVER		Part Number:	D3120-2
Inspection Dwg: D3120 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

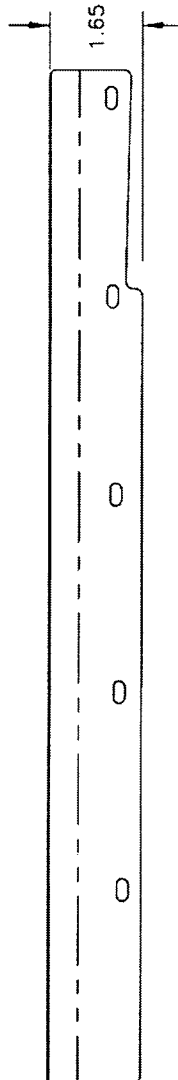
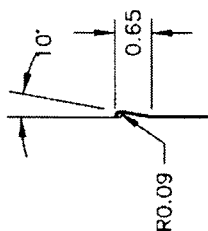
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
201 X 400	+/- .010	207 X 407	X			
.323	+/- .010	.326	X			
.388	+/- .010	.389	X			
.453	+/- .010	.455	X			
.517	+/- .010	.519	X			
.544	+/- .010	.546	X			
1.33	+/- .030	1.349	X			
1.43	+/- .030	1.425	X			
1.68	+/- .030	1.685	X			
.500	+/- .010	.500	X			
4.000	+/- .010	3.996	X			
7.500	+/- .010	7.500	X			
11.000	+/- .010	11.000	X			
14.500	+/- .010	14.500	X			
17.95	+/- .030	17.95	X			
.032	+/- .010	.032	X			

Measured by: FB	Audited by: S	Prototype Approval: n
Date: 9-8-12	Date: 09/05/13	Date: 1/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



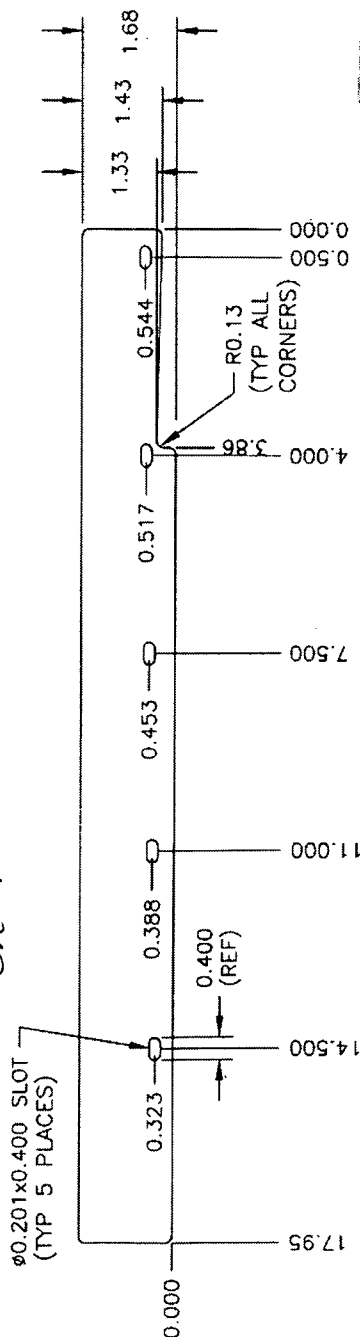
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3120	REV. B SHEET 1 OF 2
DATE 04.10.18		TITLE COVER	SCALE NTS
A	02.04.15	NEW ISSUE	
B	04.10.18	ADD PART MARKING	



BEND DETAIL

D3120-1 COVER (BEND AS SHOWN. REPLACES PREMIER P/N B30-23000-229)
D3120-2 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-230)

W/O: 50344
C209/07/14



D3120-1/-2 COVER. FLAT PATTERN

D3120-1/-2 NOTES

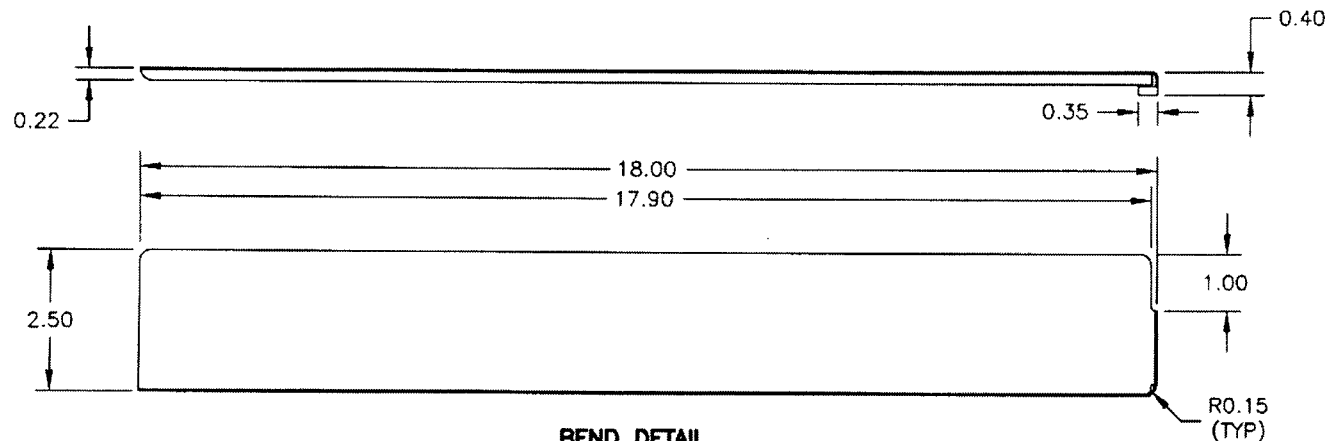
- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

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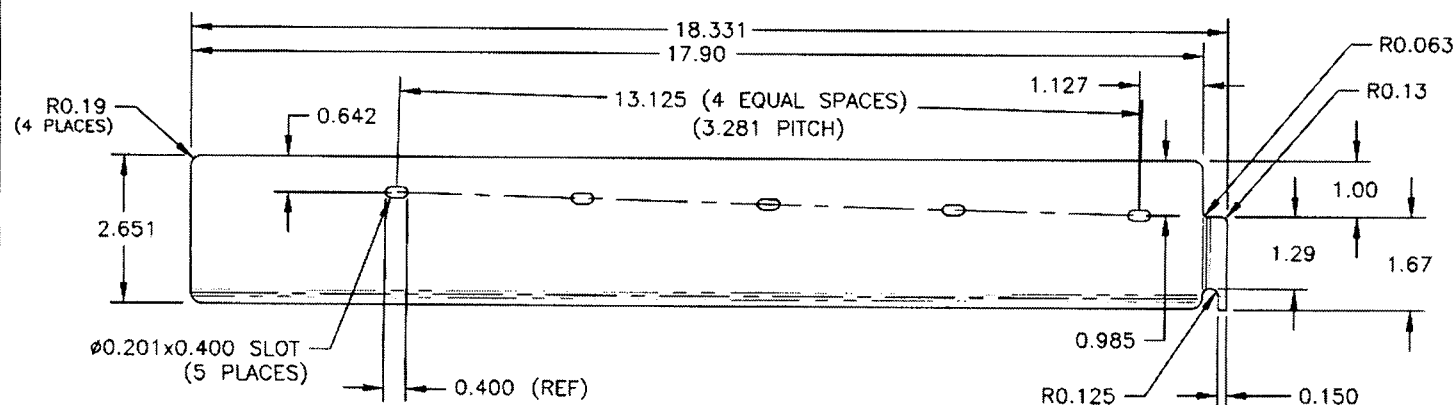


DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. B
DATE		D3120	SHEET 2 OF 2
04.10.18		TITLE	SCALE
		COVER	NTS



BEND DETAIL

D3120-3 COVER (BEND AS SHOWN. REPLACES PREMIER P/N B30-23000-231)
D3120-4 COVER (BEND OPPOSITE. REPLACES PREMIER P/N B30-23000-232)



D3120-3/-4 COVER. FLAT PATTERN

D3120-3/-4 NOTES

- 1) MATERIAL: 2024-T3 (QQ-A-250/4), 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER ON INSIDE SURFACE

50344
RELEASED
04.10.18